

Work Order ID 64073

Wednesday, November 24, 2010 8:34:51 AM



Page 1

Item ID: D2523

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 11/24/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-11-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2523	Rev A2								

100		0.00							
	BAND SAW					6	0		
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 21.75" x 12.00"								

SL 11/01/18

110		0.00							
	HAAS CNC VERTICAL MACHINING #1					6	0		
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2523								

B.A 11/01/17

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB					6	0		
QC	Memo	0.00							
Quality Control									

B.A 11/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Start Date:	11/24/2010	Start Qty:	6.00	Cust Item ID:		
Required Date:	11/30/2010	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SL 11/01/19		(6)			
140  Small Fab Small Fab	Small Fab Memo Deburr□Drill holes as per dwg D2523 using DT8560	0.00 0.00		⇒ m-l 11/01/19		(6x)			
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sulalig		(+6)			

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 6.00




Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6	6	11-01-20	
170  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 115951.</i> Memo START TIME: <i>10130</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>11.00</i>	0.00 0.00				6	6	11-01-20	
180  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6	9		<i>=> M 11/01/20</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Start Date: 11/24/2010 Start Qty: 6.00

Required Date: 11/30/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging Packaging	Identify as per dwg & Stock Location: <u>PP</u> Memo	0.00 0.00				<u>11/1/08</u>	<u>50</u>		<u>62</u>
200 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>11/01/31</u>	<u>JD</u>

C2110131

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 8:34:56 AM

Page 1

Work Order ID: 64073



Parent Item: D2523

Parent Item Name: Mounting Bracket

Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C01.04.16 Re format, added DT8560 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X12.00 0		Purchased	No			100	f	20.5690	1.8125	11.44737			



6061-T6 Bar 1.00 x 12.00



SL 10/12/20

Location	Loc Qty	Loc Code
MAT	16.569	
115255	4.569	
115844	12	
MAT05	4	
106701	4	
116406		

11.5

(* Please put back 5.75^{ft} in computer inventory because 6 blanks have been cut but 1 only used 3. (1 blank makes 2 parts) B.A 11/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64073
Description: Mounting Bracket		Part Number:	D2523
Inspection: Dwg: D2523 Rev: A2		Page 1 of 1	

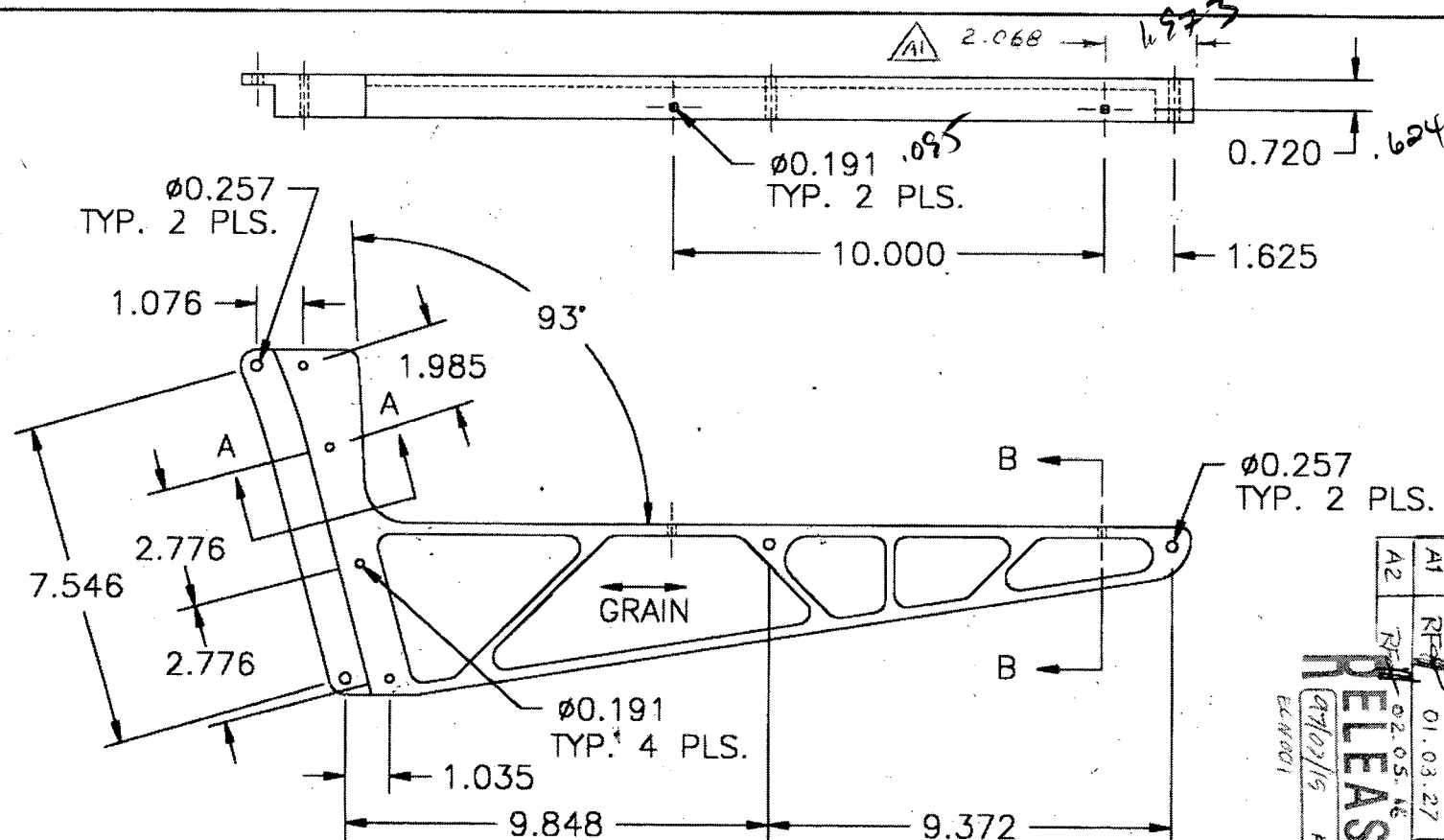
FIRST ARTICLE INSPECTION CHECKLIST

☒
First Article
☐
Prototype

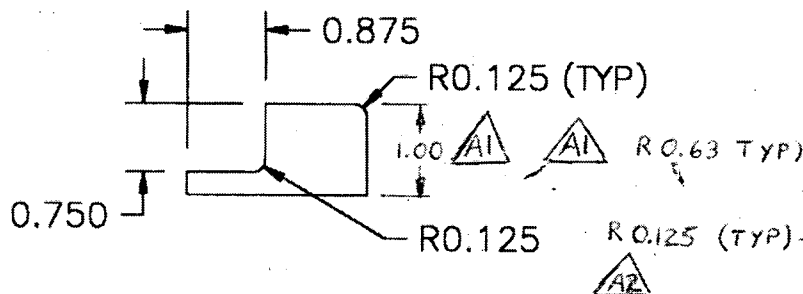
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005/-0.000	0.261	✓		Vern	GA-01
1.076	+/-0.010	1.076	✓		"	"
1.985	+/-0.010	1.985	✓		"	"
Ø0.257	+0.005/-0.001	Ø0.260	✓		"	"
9.372	+/-0.010	9.372	✓		Vern	CNC-02
1.035	+/-0.010	1.035	✓		Vern	GA-01
Ø0.191	+0.005/-0.000	Ø0.195	✓		"	"
7.546	+/-0.010	7.546	✓		Vern	CNC-02
2.776	+/-0.010	2.776	✓		Vern	GA-01
2.776	+/-0.010	2.776	✓		"	"
0.875	+/-0.010	0.874	✓		"	"
R0.125	+/-0.010	R0.125	✓		R-6	ref
1.00	+/-0.030	0.999	✓		Vern	GA-01
R0.125	+/-0.010	R0.125	✓		R-6	ref.
0.750	+/-0.010	0.747	✓		Vern	GA-01
0.250	+/-0.010	0.251	✓		"	"
R0.250	+/-0.010	R0.250	✓		R-6	ref.
0.125	+/-0.010	0.134	✓		Mic	(CNC) 118-120
R0.125	+/-0.010	R0.125	✓		R-6	ref.
R0.063	+/-0.010	R0.063	✓		R-6	ref.

Measured by:	B.A	Audited by:	SL	Prototype Approval:	N/A
Date:	11/01/17	Date:	11/01/19	Date:	N/A

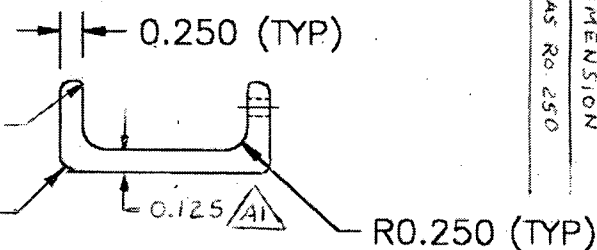
Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	



SECTION A-A
SCALE 1:2



SECTION B-B
SCALE 1:2



MATERIAL: 6061-T6 QQ-A-200/8 1.00 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBMITTAL AMENDMENT
NOTICE
ORDER
NO. 04023
2/10/11-24



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. A
CHECKED <i>BW</i>	APPROVED <i>KE</i>	DRAWING NO. D2523	SHEET 1 OF 1
DATE 95.12.20	TITLE MOUNTING BRACKET	SCALE 1:4	
A	95.12.20	NEW ISSUE	
A1	01.03.27	ADDED DIMENSION	
A2	02.05.16	R0.125 WAS R0.250	

RELEASED
07/02/15 KE
ECN 001